

22

DOOR ONLY

DART AEROSPACE LTD.	Work Order:	20785
Description: 355 Spacepod body L/H	Part Number:	D355-600-043
Drawing: D2177 Rev B, ICA-D350-600 (p.27, p.29) Rev. 0	Qty:	1
		Page 1 of 5

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Issue Work Order Print labels D0600-043 as per dwg D0600-043 Type Batch # of D350-600-043 W/O	KG	04.04.29	1
2	EXPEDITING	Photocopy blue file, print label D0600-043. & type white label per PPP D355-600-043 CHG 002			
2	COMPOSITE	Wax mould DT 8500 (body), DT8517/ DT8516 (flange), DT8519 (floor) as per QSI 006			
3	COMPOSITE	BODY Mask 3" around mould DT8500, prepare white epoxy primer or gel-coat & spray equipment Batch: _____ qty: _____			
4	COMPOSITE	BODY Spray white epoxy primer or gel-coat on DT8500 body mould. As per QSI 006 *** LAYUP TO BE DONE AFTER 12HRS & BEFORE 48HRS*** Record time after spraying: _____			
5	COMPOSITE	FLOOR Mask 3" around mould DT8519, prepare Grey epoxy primer or gel-coat & spray equipment Batch: _____ qty: _____			
6	COMPOSITE	FLOOR Spray white epoxy primer or gel-coat on DT8519 floor mould As per QSI 006 *** LAYUP TO BE DONE AFTER 12HRS & BEFORE 48HRS*** Record time after spraying: _____			
7	QC	Inspect level 11			
8	COMPOSITE	BODY Pick: Qty Part number Description Batch 2 x 15sqft FG-778150-550-ROL 9oz glass _____ 15sqft WR 1850 Woven 18oz _____ 900g 129731700 Epocast 50A _____			
9	COMPOSITE	BODY Record start time: _____ Humidity: _____ Temp.: _____ Layup glass, 2 layour of 9oz with epocast 50A & 1 layour of 18oz with epocast 50A as per dwg D2177 & QSI 006			
10	COMPOSITE	BODY Peel ply, release film, breather cloth & bag as per QSI 006 Record time: _____ *** LET CURE MIN. 24 HRS ***			
12	QC	Inspect level 11			

RELEASED

EC 00.11.07

UNDER REVIEW

02.06.18

SEE ECN: 485 (DSI 9240)

RF 02.10.15

+ CHG# 1PP/PPD 18 03.02.24

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

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Step	Location	Procedure	By	Date	qty																
13	COMPOSITE	FLOOR Pick: <table><tr><td><u>Qty</u></td><td><u>Part number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>2 x 8sqft</td><td>FG-778150-550-ROL</td><td>9oz glass</td><td>_____</td></tr><tr><td>2 x 8sqft</td><td>WR 1850</td><td>Woven 18oz</td><td>_____</td></tr><tr><td>450g</td><td>129731700</td><td>Epocast 50A</td><td>_____</td></tr></table>	<u>Qty</u>	<u>Part number</u>	<u>Description</u>	<u>Batch</u>	2 x 8sqft	FG-778150-550-ROL	9oz glass	_____	2 x 8sqft	WR 1850	Woven 18oz	_____	450g	129731700	Epocast 50A	_____			
<u>Qty</u>	<u>Part number</u>	<u>Description</u>	<u>Batch</u>																		
2 x 8sqft	FG-778150-550-ROL	9oz glass	_____																		
2 x 8sqft	WR 1850	Woven 18oz	_____																		
450g	129731700	Epocast 50A	_____																		
14	COMPOSITE	FLOOR Record start time: _____ Humidity: _____ Temp.: _____ Layup glass, 1 layour of 9oz, 2 layour of 18oz & 1 layour of 9oz with epocast 50A as per dwg D2177 & QSI 006																			
15	COMPOSITE	FLOOR Peel ply, release film, breather cloth & bag as per QSI 006 Record time: _____ *** LET CURE MIN. 24 HRS ***																			
16	COMPOSITE	FLOOR Remove bagging material after 24hrs curring, de-mould, trim using tool DT8523 prep. for bonding Record time: _____																			
17	QC	Inspect level 11																			
18	COMPOSITE	FLANGE Pick: <table><tr><td><u>Qty</u></td><td><u>Part number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>4 x 4.5sqft</td><td>FG-778150-550-ROL</td><td>9oz glass</td><td>_____</td></tr><tr><td>250g</td><td>129731700</td><td>Epocast 50A</td><td>_____</td></tr></table>	<u>Qty</u>	<u>Part number</u>	<u>Description</u>	<u>Batch</u>	4 x 4.5sqft	FG-778150-550-ROL	9oz glass	_____	250g	129731700	Epocast 50A	_____							
<u>Qty</u>	<u>Part number</u>	<u>Description</u>	<u>Batch</u>																		
4 x 4.5sqft	FG-778150-550-ROL	9oz glass	_____																		
250g	129731700	Epocast 50A	_____																		
19	COMPOSITE	FLANGE Record start time: _____ Humidity: _____ Temp.: _____ Layup glass, 4 layour of 9oz, with epocast 50A as per dwg D2177 & QSI 006																			
20	COMPOSITE	FLANGE Peel ply as per QSI 006 Record time: _____ *** LET CURE MIN. 24 HRS ***																			
21	COMPOSITE	FLANGE Remove peel ply, after 24hrs curring, de-mould, prep. for bonding Record time: _____																			
22	QC	Inspect level 11																			

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NOV 07 2000

UNDER REVIEW

Dart Aerospace Ltd

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		Page 3 of 5

Step	Location	Procedure	By	Date	qty
23	COMPOSITE	BODY Pick: <u>Qty</u> <u>Part number</u> <u>Description</u> <u>Batch</u> 2"x24" COR A5003/8PH32 Core _____ 5"x36" COR A5001PH32 Core _____ 1oz FIL K20 3M glass bubbles _____ 4oz VNT milledfiber "E" glass _____ 150g 129731700 Epocast 50A _____ 8 D2213 Spacer _____			
24	COMPOSITE	BODY Record time: _____ Temp.: _____ Humidity: _____ Bond flange in body using trim tool DT8501 as per dwg D2177 using epoxy resine 50A, glass bubbles & milled fiber (24hrs cure min.) as per QSI 006			
25	COMPOSITE	BODY Record time: _____ Temp.: _____ Humidity: _____ Router core & Bond as per dwg D2177 to outer skin using epoxy resine 50A & micro bubbles Bag ass'y for curing (24hrs in bag min.) as per QSI 006			
26	COMPOSITE	Remove bag & sand if required Record time: _____			
27	QC	Inspect level 11			
28	COMPOSITE	BODY De-mould body Install spacer D2213 with epoxy 50A & milled fiber as per dwg D2177, hold in place using tooling bolts (24hrs cure min.) as per QSI 006			
29	COMPOSITE	Pick: <u>Qty</u> <u>Part number</u> <u>Description</u> <u>Batch</u> 2 x 8sqft FG-778150-550-ROL 9oz glass _____ 300g 129731700 Epocast 50A _____			
30	COMPOSITE	BODY Record time: _____ Temp.: _____ Humidity: _____ Put part in DT8500 mould layup 2 layour of 9oz glass on sides & top of body using epoxy resine 50A, Bag ass'y (24hrs cure min.) as per QSI 006			
31	COMPOSITE	Remove bag & sand if required Record time: _____			
32	QC	Inspect level 11			

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

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		Page 4 of 5

Step	Location	Procedure	By	Date	qty																				
33	COMPOSITE	Fill pod body bottom with vultafoam (let cure 12hrs) Record time:																							
34	COMPOSITE	Cut vultafoam flush with inboard & outboard edges, fill any voids Record time:																							
35	COMPOSITE	Dry fit floor																							
36	QC	Inspect level 11																							
37	COMPOSITE	BODY Pick: <table><tr><td>Qty</td><td>Part number</td><td>Description</td><td>Batch</td></tr><tr><td>1oz</td><td>FIL K20</td><td>3M glass bubbles</td><td></td></tr><tr><td>200g</td><td>129731700</td><td>Epocast 50A</td><td></td></tr></table>	Qty	Part number	Description	Batch	1oz	FIL K20	3M glass bubbles		200g	129731700	Epocast 50A												
Qty	Part number	Description	Batch																						
1oz	FIL K20	3M glass bubbles																							
200g	129731700	Epocast 50A																							
38	COMPOSITE	Bond floor in place with epocast 50A, glass bubllies as per QSI 006																							
39	COMPOSITE	Pick: <table><tr><td>Qty</td><td>Part number</td><td>Description</td><td>Batch</td></tr><tr><td>2sqft</td><td>FG-778150-550-ROL</td><td>9oz glass</td><td></td></tr><tr><td>50g</td><td>129731700</td><td>Epocast 50A</td><td></td></tr><tr><td>1sqft</td><td>VS Genmat</td><td>surface vail 39</td><td></td></tr><tr><td>1</td><td>D2986-1</td><td>Rubber spacer</td><td></td></tr></table>	Qty	Part number	Description	Batch	2sqft	FG-778150-550-ROL	9oz glass		50g	129731700	Epocast 50A		1sqft	VS Genmat	surface vail 39		1	D2986-1	Rubber spacer				
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50g	129731700	Epocast 50A																							
1sqft	VS Genmat	surface vail 39																							
1	D2986-1	Rubber spacer																							
40	COMPOSITE	Record time:_____Temp.:_____ Humidity:_____ Layup glass, 2 layour of 9oz at floor to flange joint, peel ply as per dwg D2177 & QSI 006 (24hrs cure min.) as per QSI 006																							
41	COMPOSITE	Record time:_____Temp.:_____ Humidity:_____ Apply decal D0600-043 cover with surface vail as per dwg D2177 ****Ensure batch# on decal matches D350-600-043 W/O # **** record batch # on label:_____ (24hrs cure min.) as per QSI 006																							
42	COMPOSITE	Fill & fair all parts as required using BMS 5-136A Batch:_____																							
43	COMPOSITE	Mask label & floor																							
44	COMPOSITE	Prime with white primer as required Batch:_____																							
45	QC	Inspect level 11																							
46	COMPOSITE	Mask for speckel paint																							
47	COMPOSITE	Speckel paint as per dwg D2177																							

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NOV 07 2000

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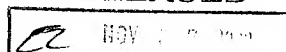
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		Page 5 of 5	

Step	Location	Procedure	By	Date	qty																																												
48	COMPOSITE	Clearcoat as per dwg D2177 & let dry																																															
49	COMPOSITE	Bond D2986-1 under floor using contact cement.																																															
50	COMPOSITE	Wing walk top surface of pod as per dwg D2177 & QSI 005 4.4																																															
51	QC	Inspect level 5																																															
3	STORES	<table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D350-600-045</td><td>Spacepod door</td><td>_____</td></tr><tr><td>1</td><td>D2177-3</td><td>Spacepod body</td><td>_____</td></tr><tr><td>1</td><td>D2219</td><td>Door support brkt</td><td>_____</td></tr><tr><td>2</td><td>D2237</td><td>Striker plate</td><td>_____</td></tr><tr><td>1</td><td>5/16-18 unc ^{D3045-3}</td><td>Lock nut</td><td>_____</td></tr><tr><td>1</td><td>AN960JD516</td><td>Washer</td><td>_____</td></tr><tr><td>1</td><td>SL69-BS</td><td>Ball stud</td><td>_____</td></tr><tr><td>6</td><td>MS20426AD4-5</td><td>Rivet</td><td>_____</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D350-600-045	Spacepod door	_____	1	D2177-3	Spacepod body	_____	1	D2219	Door support brkt	_____	2	D2237	Striker plate	_____	1	5/16-18 unc ^{D3045-3}	Lock nut	_____	1	AN960JD516	Washer	_____	1	SL69-BS	Ball stud	_____	6	MS20426AD4-5	Rivet	_____											
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1	SL69-BS	Ball stud	_____																																														
6	MS20426AD4-5	Rivet	_____																																														
4	QC	Assemble as per dwg ICA-D350-600																																															
5	QC	Inspect Level 5																																															
6	STORES	<table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2174-041</td><td>Web assembly</td><td>_____</td></tr><tr><td>16</td><td>A3235-020-935</td><td>Washer</td><td>_____</td></tr><tr><td>8</td><td>AN3-3A</td><td>Bolt</td><td>_____</td></tr><tr><td>8</td><td>AN960JD10</td><td>Washer</td><td>_____</td></tr><tr><td>16</td><td>AN960JD10L</td><td>Washer</td><td>_____</td></tr><tr><td>16</td><td>MS21042L3</td><td>Nut (or-3)</td><td>_____</td></tr><tr><td>8</td><td>MS24694S54</td><td>Screw</td><td>_____</td></tr><tr><td>8</td><td>MS24694S67</td><td>Screw</td><td>_____</td></tr><tr><td>8</td><td>NAS1329A3K80</td><td>Insert</td><td>_____</td></tr><tr><td>1</td><td>D2985</td><td>Decal</td><td>_____</td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	D2174-041	Web assembly	_____	16	A3235-020-935	Washer	_____	8	AN3-3A	Bolt	_____	8	AN960JD10	Washer	_____	16	AN960JD10L	Washer	_____	16	MS21042L3	Nut (or-3)	_____	8	MS24694S54	Screw	_____	8	MS24694S67	Screw	_____	8	NAS1329A3K80	Insert	_____	1	D2985	Decal	_____			
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16	MS21042L3	Nut (or-3)	_____																																														
8	MS24694S54	Screw	_____																																														
8	MS24694S67	Screw	_____																																														
8	NAS1329A3K80	Insert	_____																																														
1	D2985	Decal	_____																																														
7	QC	Inspect Level 4																																															
8	STORES	Package per PPP D355-600-043																																															
52	QC	Identify & stock																																															
53	EXPEDITING	Close Work Order Job Cost / Part																																															

Rev	Date	Change	revised by	approved
A	00.06.13	New Issue	EC	
B	00.07.07	Revised, Added CHG 001 (MPP 2074)	EC	
C	00.11.06	Revised, Added CHG 001 (MPP 2074)	EC	

UNDER REVIEW

RELEASED



SEE ECN: 485 (DSI 9240)
RF 02.10.15

Dart Aerospace Ltd

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NCR		WORK ORDER NON-CONFORMANCE						
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PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2177	REV. B SHEET 1 OF 7
DATE 00.09.06		TITLE SPACEPOD BODY	SCALE NTS
A	93.08.20	NEW ISSUE	
B	00.09.06	REDRAWN; CHANGE MATERIAL SPEC	

RELEASED
00.09.13 #

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

PRIMER: EPOXY PRIMER WHITE 4500-PB-40 (2 PART PRIMER)
EPOXY PRIMER GREY #16473 4500-PB-40B (2 PART PRIMER)

CORE: GELCOTE VULTAFOAM W9900 A/B (LIQUID FOAM)
CORE CELL A500 1.00" THICK (1.00 FOAM)
CORE CELL A500 0.38" THICK (0.38 FOAM)

4. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D2177-1	DT8003	DT8501
D2177-2	DT8004	DT8502
D2177-3	DT8500	DT8501

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WORK ORDER

NO. 20785

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. APPLY GREY SPACKLE AND CLEARCOAT TO INSIDE SURFACES OF POD.
7. INSTALL D2986-1 RUBBER SPACER ON BOTTOM SIDE OF SPACEPOD FLOOR USING CONTACT CEMENT. TRIM SPACER TO FIT.

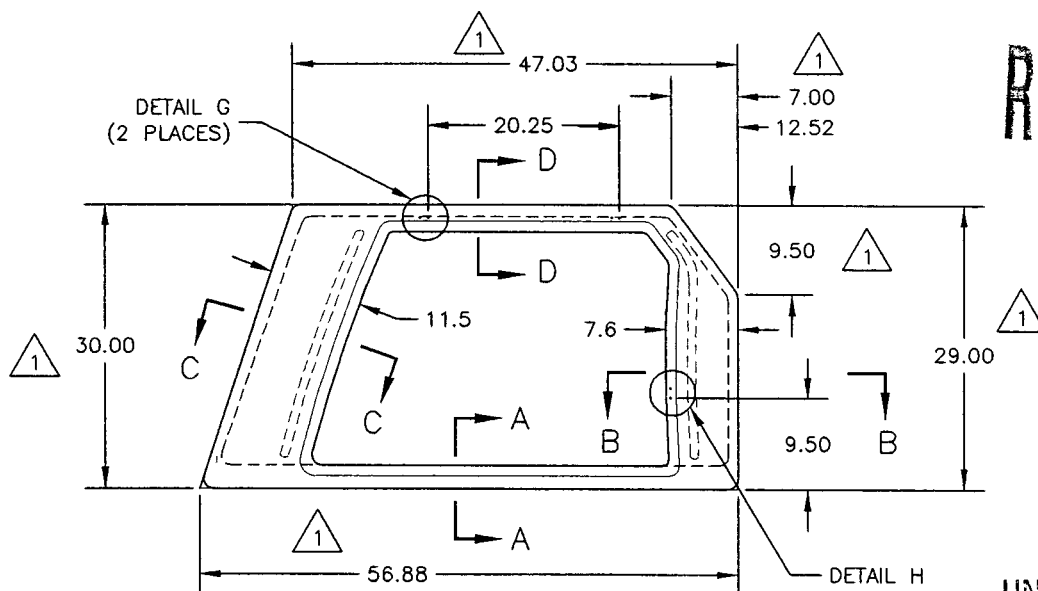
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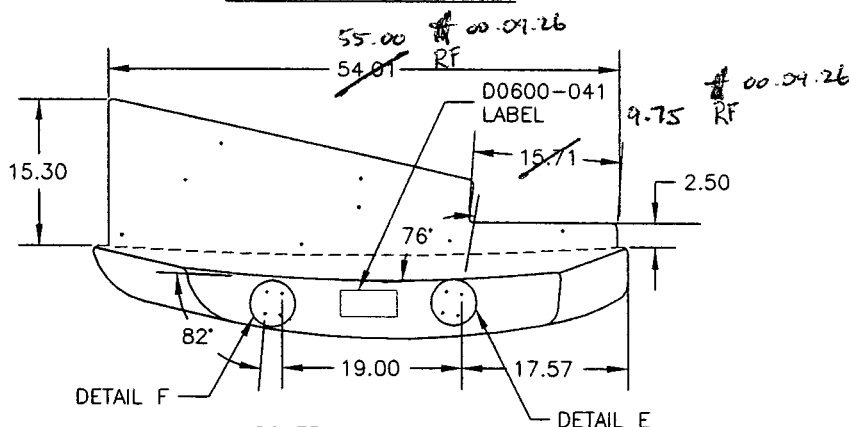
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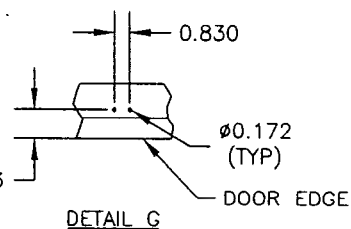
DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2177	REV. 8 SHEET 2 OF 7
DATE 00.09.06	TITLE SPACEPOD BODY		SCALE NTS



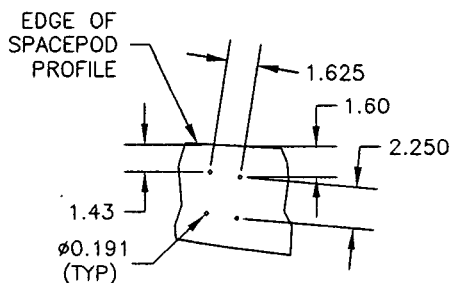
D2177-1 SPACEPOD BODY



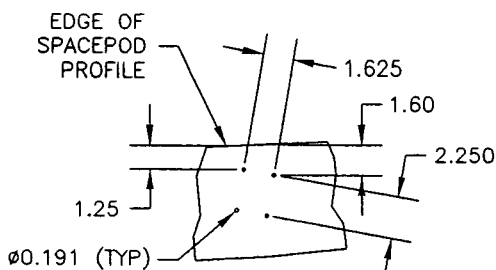
D2177-1 TOP VIEW



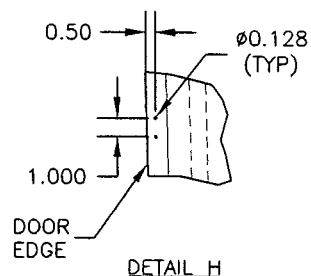
DETAIL G



DETAIL F



DETAIL E



DETAIL H

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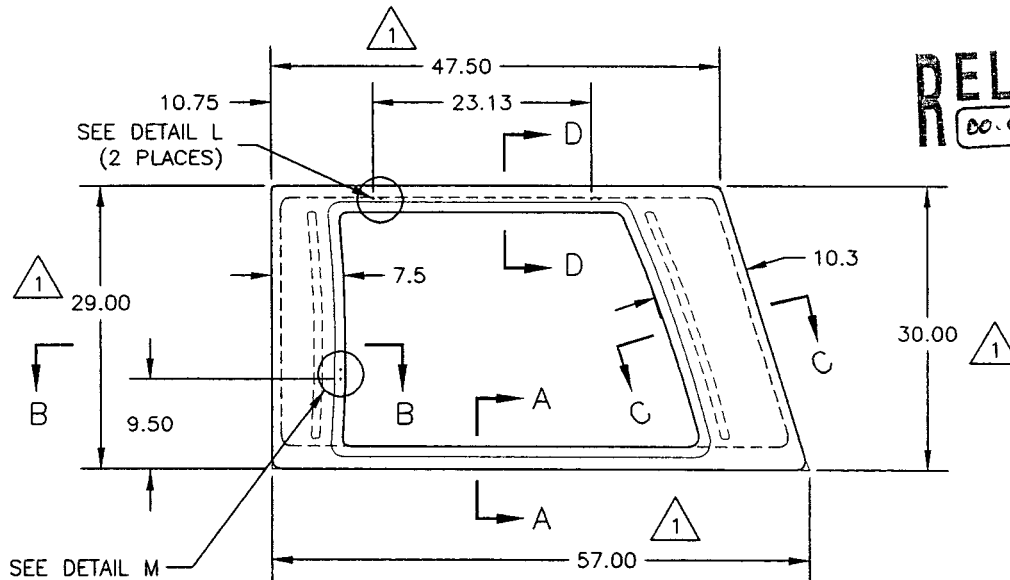
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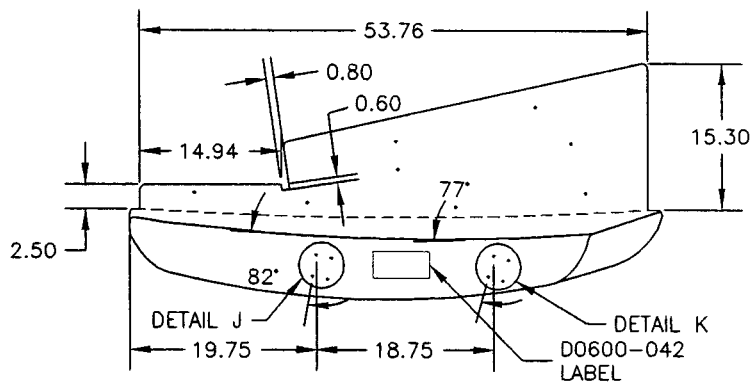
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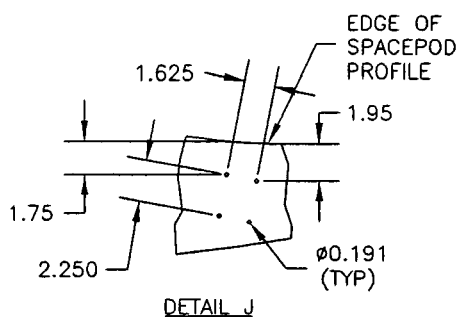
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DATE 00.09.06	TITLE SPACEPOD BODY		SCALE NTS



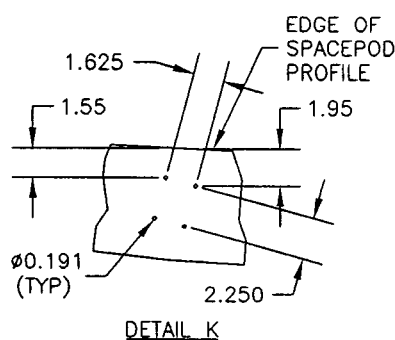
D2177-2 SPACEPOD BODY



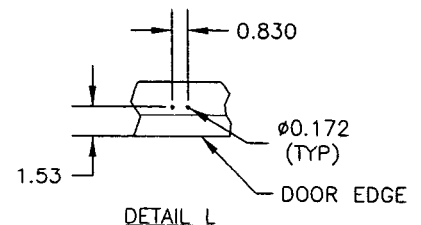
D2177-2 TOP VIEW



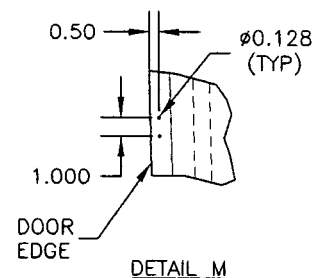
DETAIL J



DETAIL K



DETAIL L



DETAIL M

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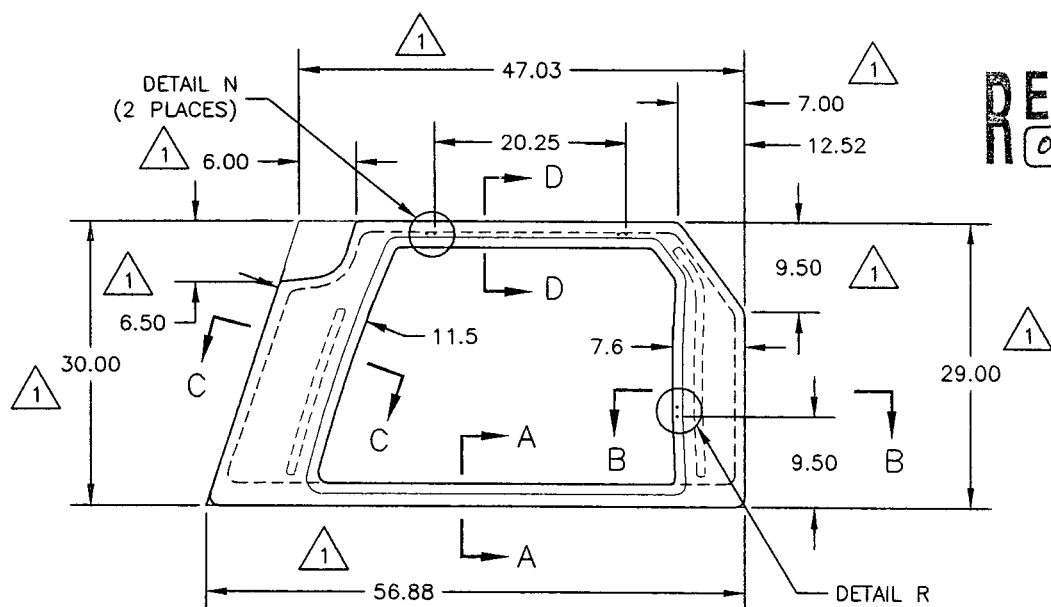
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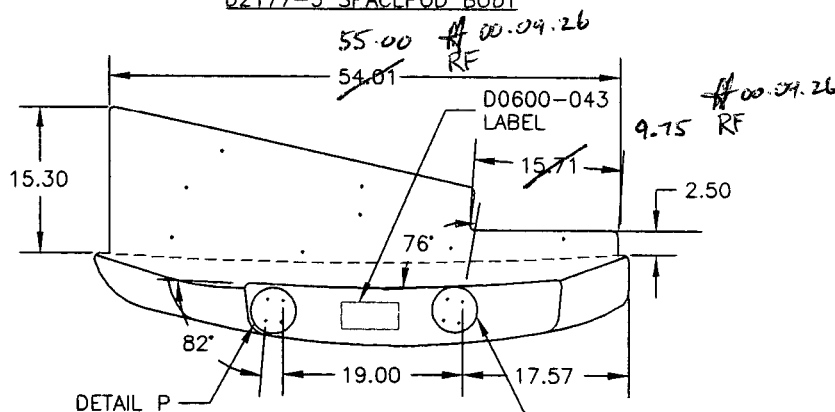
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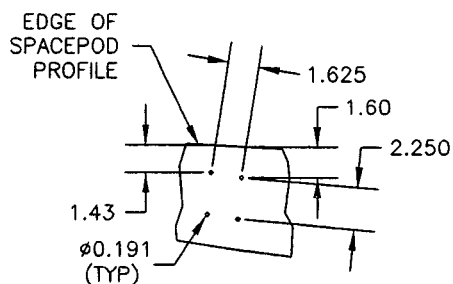
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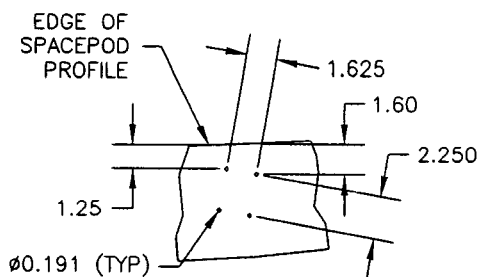
D2177-3 SPACEPOD BODY



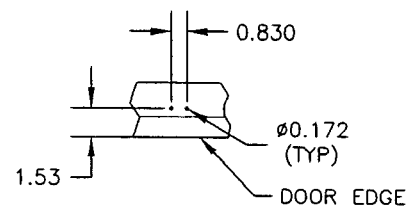
D2177-3 TOP VIEW



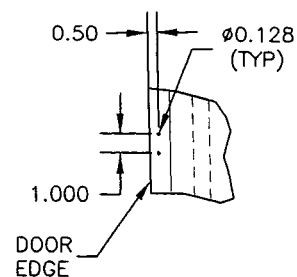
DETAIL P



DETAIL Q



DETAIL N



DETAIL R

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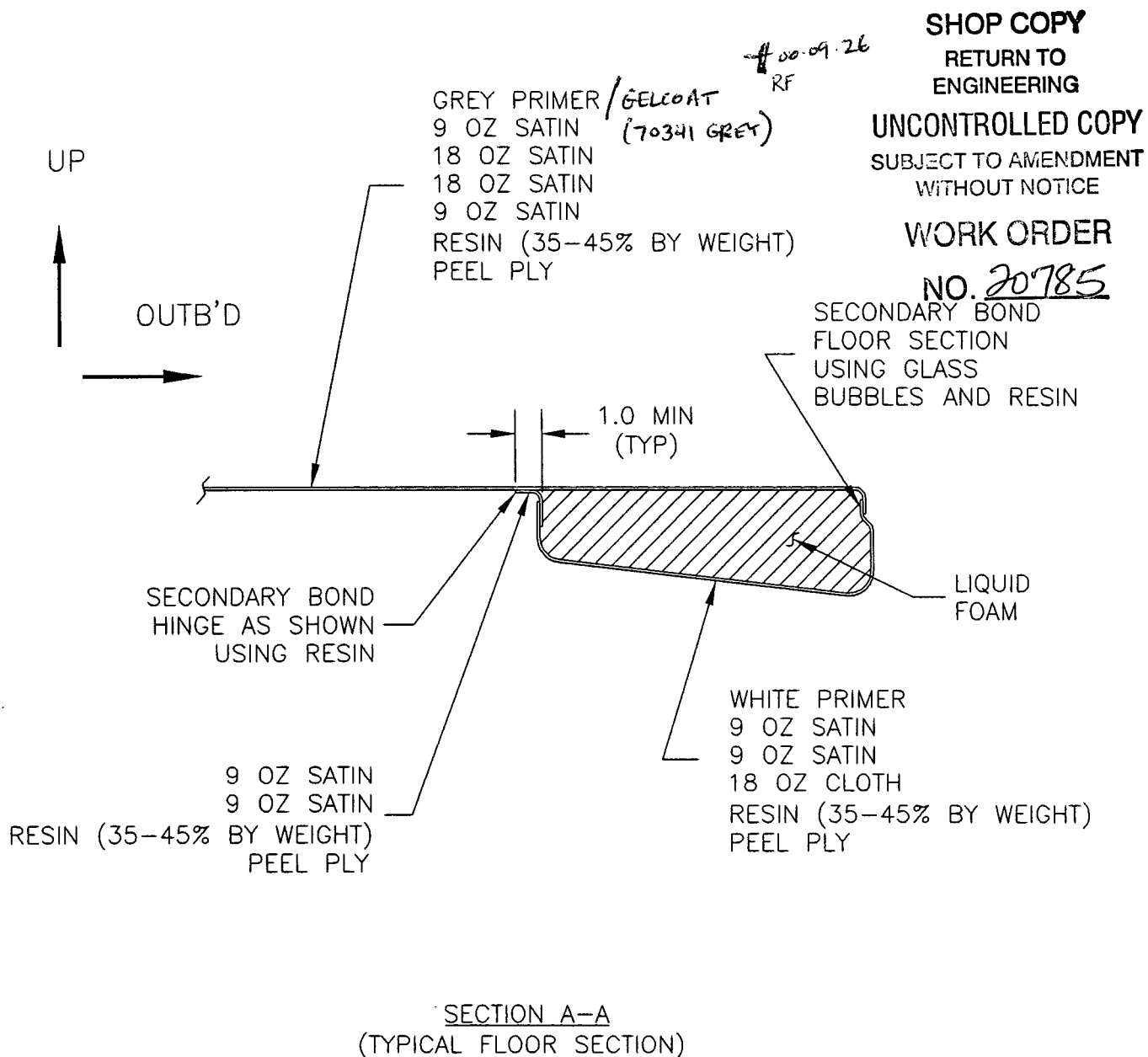
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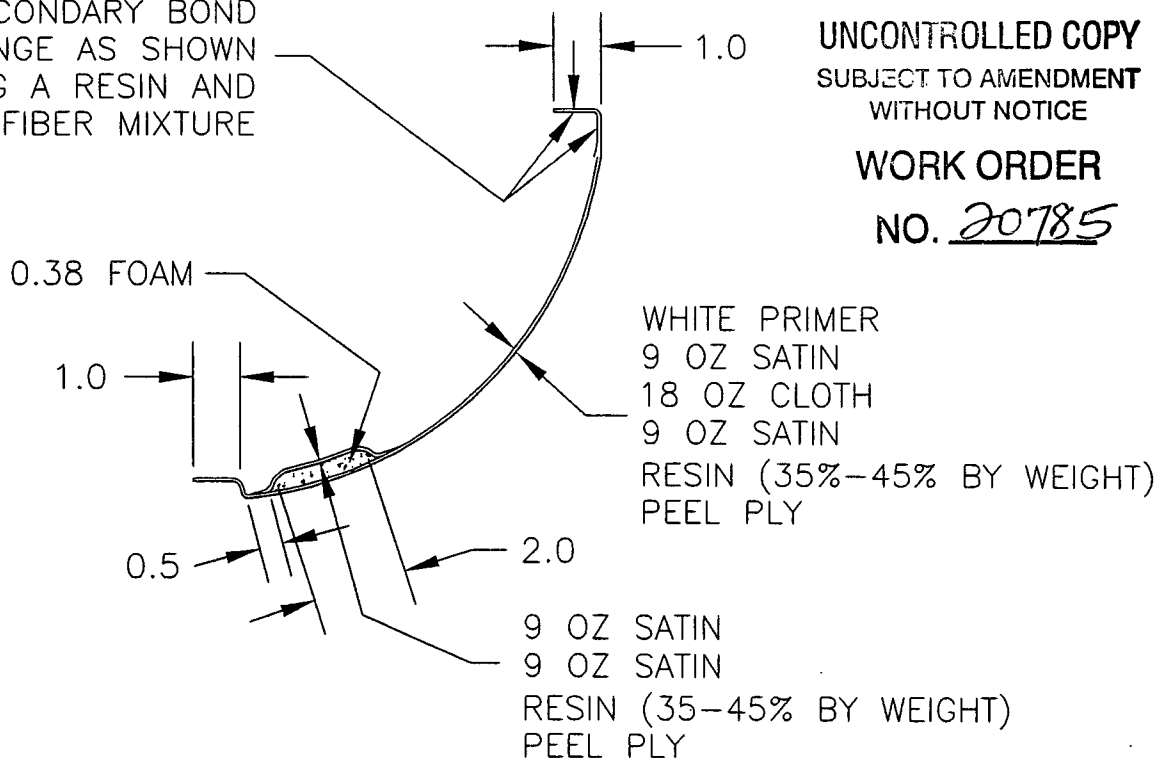
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MILLED FIBER MIXTURE



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SECTION B-B
(SECTION C-C SIMILAR)

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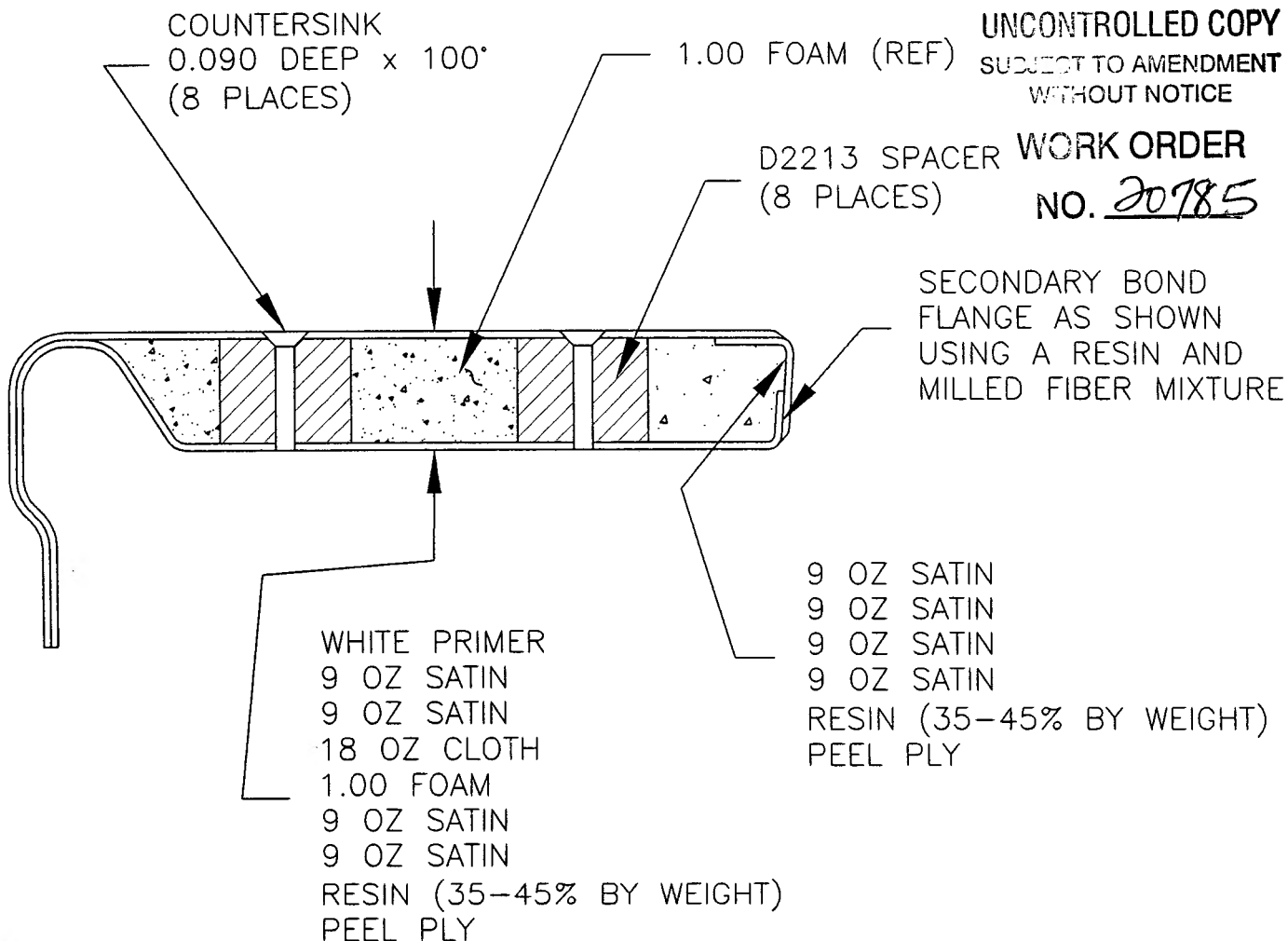
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SECTION D-D
(TYPICAL ROOF SECTION)

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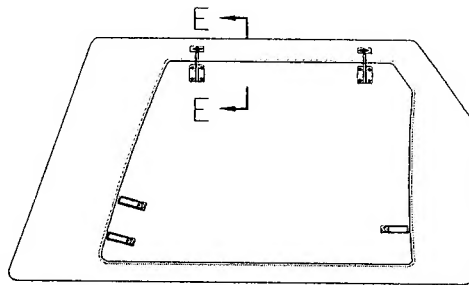


FIGURE 3. LOOKING AT OUTSIDE OF
D350-600-145 DOOR
(D350-600-146 SIMILAR AND OPPOSITE)

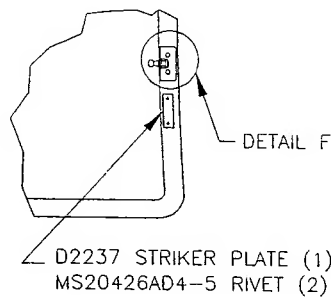


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

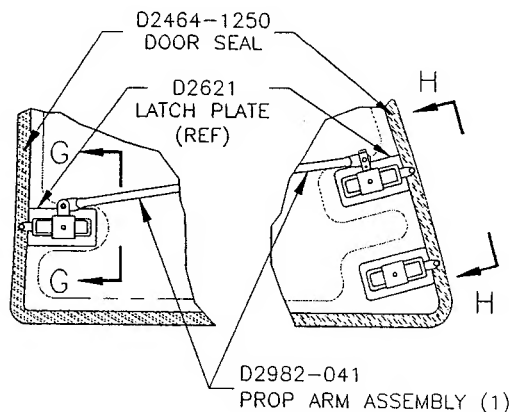
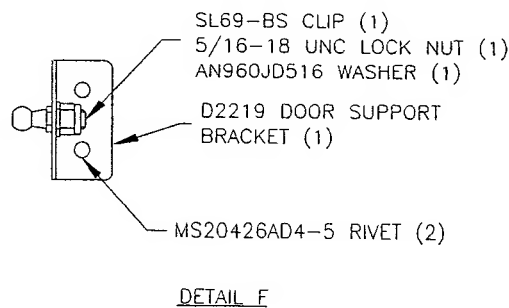


FIGURE 5. LOOKING AT TYPICAL INSIDE
OF D350-600-145/-146 DOOR



DETAIL F

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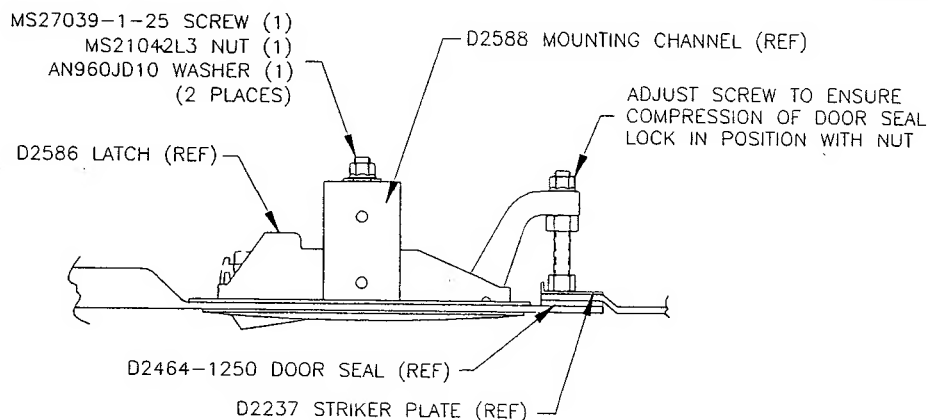
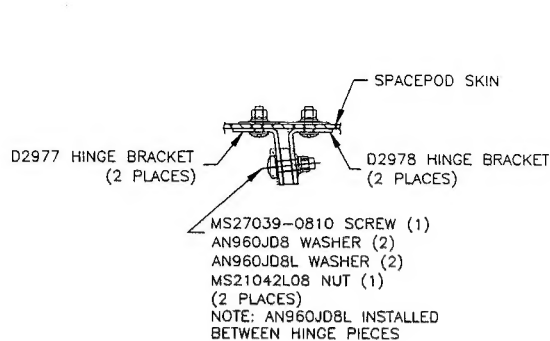
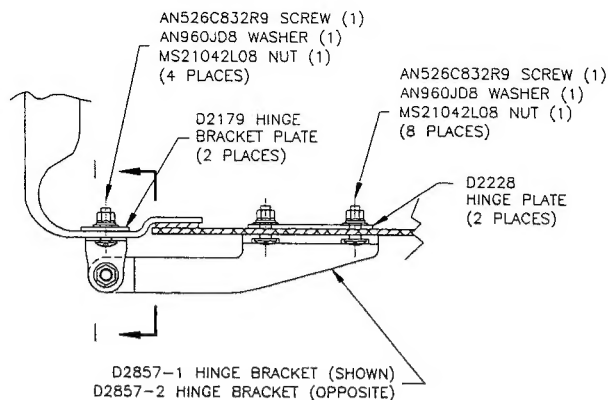


FIGURE 6. TYPICAL LATCH INSTALLATION

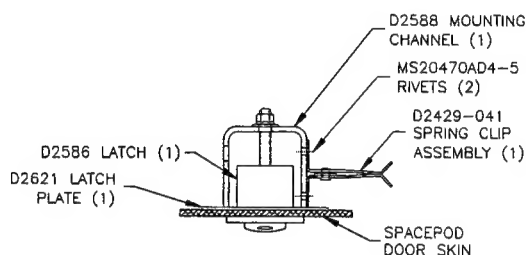
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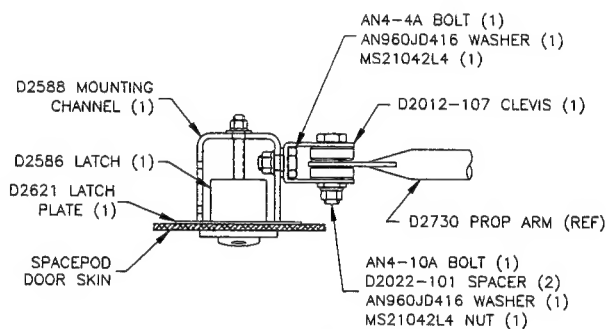
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 SPACEPOD™ REMOVAL

1. Remove D350-600-045/-145 or -046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove **Spacepod™** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 29, 2004
10:07 am

Work Order No : 0020785
Project Name : *D355-600-043
Project For : WK422
Work Order Type : Main
Main WO Number :
House Part Number : *D355-600-043
Description : Spacepod LH
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 04-28-04
Est Finish Date : 05-27-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00